

Work Order ID 83462

April-18-12 11:33:47 AM

SHIP
TODAY

83462

Page 1

Item ID: E4629-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel

Start Date: 18/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 12/04/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

E4629

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

6061. 125

2- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

RA

①

Ø

Jm

12-4-20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83462

83462

Page 2

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel

Start Date: 18/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC7-Inspect Chemical Conversion Coat

0.00

140

QC

Memo

0.00

Quality Control

Handwritten notes and signatures:

- IX
- Handwritten signature
- 12/04/23
- Handwritten signature
- 12/4/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 83462***83462***

Page 3

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Item ID: E4629-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Panel

Stop ***NS2***

Start Date: 18/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 25/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MLJ 12/04/23

D12-01-23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

April-18-12 11:33:50 AM

Page 1

Work Order ID: 83462

83462

Parent Item: E4629-1

F4629-1

Parent Item Name: Panel

Start Date: 18/04/2012

Required Date: 25/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.04.11 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	60.7000	1.52	1.6			

M6061T6S 125

6061-T6 .125 Sheet

**

Location

Loc Qty

Loc Code

MAT021

60.7

113608

46.69

119513

10.8

120218

3.21

121473

u for less 1204.23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 83462
Description: PANEL		Part Number: D4629-1
Inspection Dwg: D4629-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 164	+0.005 -0.001					
Ø 170	+0.006 -0.001	176	2		V	B07
Ø 500	+0.006 -0.001	503	2		V	
Ø 630	+0.008 -0.001	631	2		V	
Ø 750	+0.005 -0.001	754	2		V	
Ø 1960	+0.02 -0.001					
Ø 3170	+0.02 -0.001					
70	±0.30	704	2		V	
160	±0.30	1606	2		V	
1.46	±0.30	1.346	2		V	
50	±0.30	504	2		V	
1.18	±0.30	1.186	2		V	
3.18	±0.30	3.173	2		V	
4.25	±0.30	4.246	2		V	
6.33	±0.30	6.328	2		V	
1.85	±0.30	1.851	2		V	
2.91	±0.30	2.912	2		V	
4.10	±0.30	4.103	2		V	
4.14	±0.30	4.150	2		V	
6.35	±0.30	6.348	2		V	
8.66	±0.30	8.60	2		P	Row 307
9.76	±0.30	9.768	2		P	
10.85	±0.30	10.860	2		P	

Measured by: PB	Audited by:	Prototype Approval:
Date: 12-4-03	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 83462
Description: PANEL		Part Number: D4629.1
Inspection Dwg: D4629-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.49	$\pm .03$	12.49	X		T 1801	
12.79	$\pm .03$	12.79	2		T	
12.92	$\pm .03$	12.92	2		T	
13.75	$\pm .03$	13.75	2		T	
14.24	$\pm .03$	14.24	>		T	
15.40	$\pm .03$	15.40	2		V 1802	
.179	$\pm .003$.1803	2		V	
5.41	$\pm .03$	5.417	2		V	
10.75	$\pm .03$	10.75	2		P 1803	
12.82	$\pm .03$	12.82	2		T	
.67	$\pm .03$.673	2		V	
2.37	$\pm .03$	2.371	2		V	
2.91	$\pm .03$	2.919	2		V	
5.56	$\pm .03$	5.561	2		V	
7.00	$\pm .03$	7.005	2		V	
8.05	$\pm .03$	8.060	2		P	
8.75	$\pm .03$	8.743	2		P	
10.55	$\pm .03$	10.560	2		P	
11.55	$\pm .03$	11.559	1		P	
12.55	$\pm .03$	12.55	2		T	
1.26	$\pm .03$	1.268	2		V	
3.50	$\pm .03$	3.501	2		V	
5.39	$\pm .03$	5.400	1		V	

Measured by: RB	Audited by:	Prototype Approval:
Date: 12-4-23	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 83462
Description: PANEL		Part Number: D4679-1
Inspection Dwg: D4679-1, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

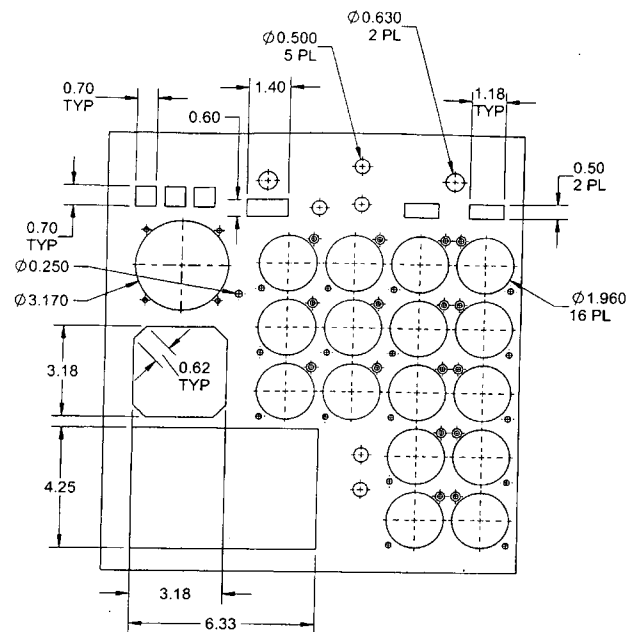
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.76	± .03	5.762	2		V BoZ	
6.88	± .03	6.882	2		V	
8.01	± .02	8.010	2		Provision	
9.66	± .02	9.666	2		P	
10.03	± .02	10.043	2		P	
11.62	± .02	11.62	2		P	
14.20	± .03	14.20	2		T BoZ	
16.71						
2.71						
2.81						
2.86						
3.00						
3.05						
8.75						
.125	± .010	.124	2		V	
Ø .201	± .005 - .001				V	

Measured by: B	Audited by:	Prototype Approval:
Date: 12-4-03	Date:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83462 MLC
12/04/18



E4629-1 PANEL

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/11 OR AMS-QQ-A250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
2024-T3 ALUMINUM SHEET, 0.125 THICK
PER QQ-A-250/4 OR AMS-QQ-A250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.46 lbs

RELEASED
2012-04-05
MAY

A NEW ISSUE		DC	12.03.23
REV.		BY	DATE
DESIGN	DC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	DC		
CHECKED	FE	DRAWING NO.	REV. A
MFG. APPR.	FE	E4629	SHEET 1 OF 5
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	PANEL (TRAVIRA)	NTS
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Dart Aerospace Ltd

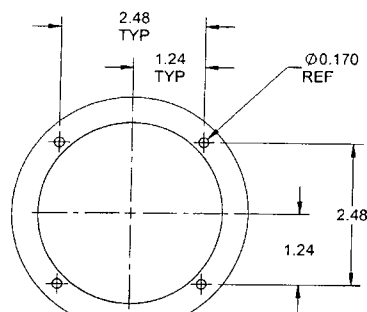
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

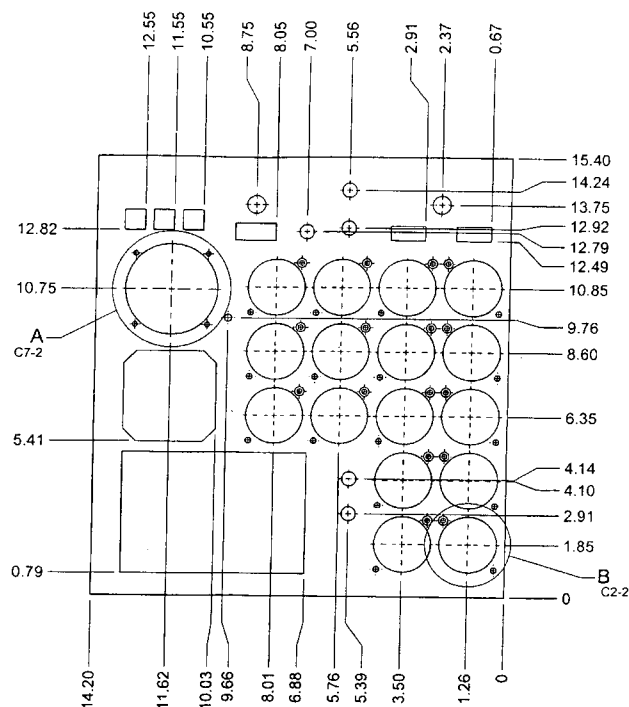
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

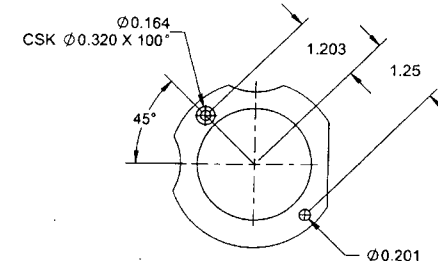
NOTE: Date & initial all entries



DETAIL A
C5-2



E4629-1 PANEL
AUXILIARY VIEW



DETAIL B
84-2
5 PL
11 PL, VERTICAL MIRROR

RELEASED
2012-03-03

DESIGN	BC	EAGLE COPTERS LTD CALGARY, ALBERTA, CANADA	
DRAWN	BC		
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4629	SHEET 2 OF 5
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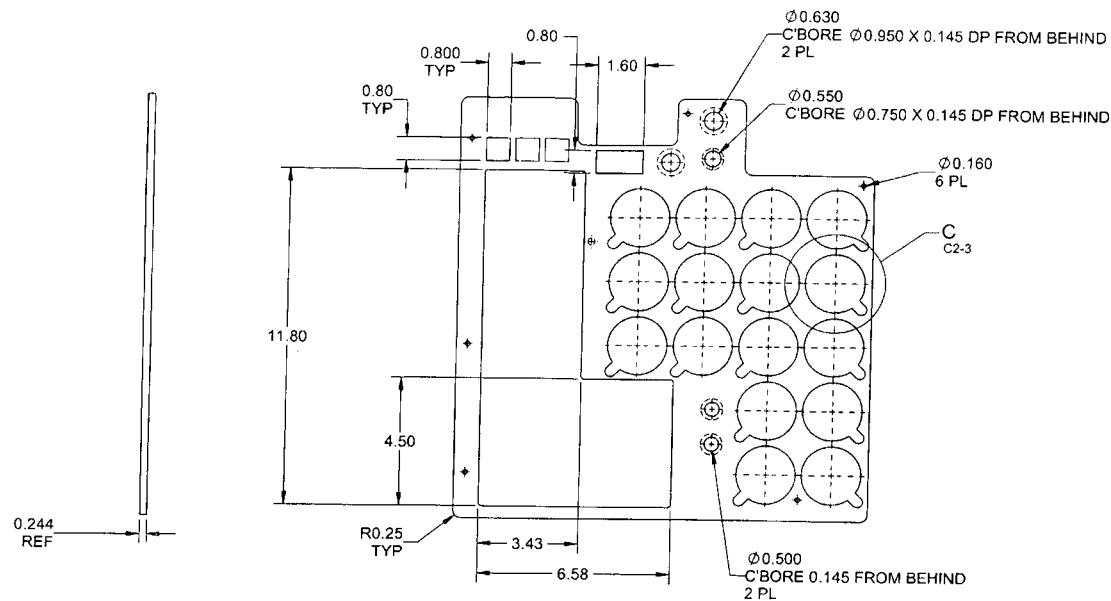
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83462



E4629-3 OVERLAY PANEL

RELEASE
2012-04-05

NOTES:

- 1) MATERIAL: MANUFACTURED BY ANODYNE ELECTRONICS MANUFACTURING CORP.
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN	BC	EAGLE COPTERS LTD	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	BC	DRAWING NO.	REV. A
MFG. APPR.	BC	E4629	SHEET 3 OF 5
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	PANEL (TRAVIRA)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

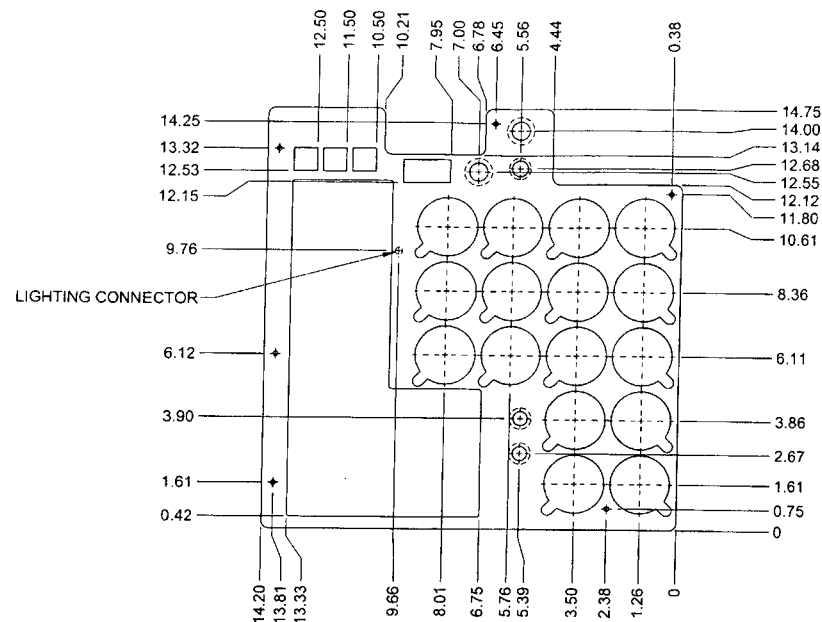
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8/3/4/62



E4629-3 OVERLAY PANEL
AUXILIARY VIEW

RELEASED
2012-04-01
CWP

DESIGN	BC	EAGLE COPTERS LTD	
DRAWN	BC	CALGARY, ALBERTA, CANADA	
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	AB	E4629	SHEET 4 OF 5
APPROVED	N/A	TITLE	SCALE
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DO NOT OPERATE HEATER
ABOVE 21 DEG C OUT AIR TEMP

EMERG

CARGO

FLOATS

REL

0.12
TYP

PRESS-TO-TEST

MAIN
OFF
RESERVE

BAGGAGE FIRE TEST

HYDR SYS 1

HYDR SYS 2

AMMETER

FUEL QTY

VOLTMETER 1

VOLTMETER 2

DIGITS
TEST

T
O
T
A
L
FWD
TANK
MID
TANK

GEAR BOX

XMSN

0.16
TYP

F
I
R
E
E
X
T

9

0.10
TYP

0.36
TYP

8

10

E4629-3 OVERLAY PANEL
AUXILIARY VIEW

2012-04-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WHITE TEXT ON BLACK BACKGROUND
- 9) WHITE TEXT ON LIGHT GREY BACKGROUND
- 10) HATCHED AREA IS BLACK BACKGROUND

DESIGN	DC	EAGLE COPTERS LTD	
DRAWN	DC	CALGARY, ALBERTA, CANADA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	RB	E4629	SHEET 5 OF 5
APPROVED	N/A	TITLE	SCALE
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NOTE: Date & initial all entries

[8:46:20 AM] Linda Lacelle: Harvey?
[8:46:36 AM] Harvey Siemens: GML
[8:46:46 AM] Linda Lacelle: D4631 panel...just did the FAI and the measurments are no good...
[8:46:57 AM] Linda Lacelle: can you check the dcf pls
[8:47:00 AM] Linda Lacelle: dxf
[8:47:35 AM] Harvey Siemens: Which project is that for?
[8:48:11 AM] Linda Lacelle: it was for a PO sent in on Thursday from Eagle...PO 12-001737
[8:48:19 AM] Harvey Siemens: Ok, got it
[8:48:28 AM] Linda Lacelle: might as well check the D4629-1 also..PO 12-001735
[8:48:58 AM] Harvey Siemens: ok will do
[8:49:05 AM] Linda Lacelle: thx
[8:52:23 AM] Harvey Siemens: Is there a particular dim thats out?
[8:52:36 AM] Harvey Siemens: Nothing has changed as far as i can tell here.
[8:53:28 AM] Linda Lacelle: measuring from the side where the square side is, it's all off..
[8:54:45 AM] Linda Lacelle: like 1/4"
[8:55:54 AM] Harvey Siemens: Let me check
[9:29:17 AM] Harvey Siemens: Dont know what to say Linda, DXF matches the part at my end.
[9:29:29 AM] Harvey Siemens: Shall i remake the DXF and send it to you?
[9:29:56 AM] Harvey Siemens: E4629 looks good too ... at my end
[9:43:20 AM] Linda Lacelle: maybe we should just send the parts?
[10:21:23 AM] Linda Lacelle: so?
[11:34:55 AM] Harvey Siemens: Send me the parts and i'll see if they will work
[11:37:00 AM] Linda Lacelle: ok, thx